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COUNTRY Hungary/USSR			
SUBJECT Specialized Shoe Enterprise, Budapest ("Martekutani Cipokesszito Vallalat")/Procedures Used in Manufacture of Custom-built Shoes	DATE DISTRIBUTED 29 November 1957 NO. OF PAGES 3 NO. OF ENCLS. SUPPLEMENT TO REPORT # 		
THIS IS UNEVALUATED INFORMATION			
<ol style="list-style-type: none"> 1. The Specialized Shoe Manufacturing Enterprise ("Shoes Made to Measure"), Budapest ("Martekutani Cipokesszito Vallalat") produced a limited number of high-quality, custom-made shoes which were made to measure and by hand. This type of production is to be differentiated from the production of a series of shoes and sizes as usually is the case in shoe factories. The purpose was to make fewer samples which were prepared with a special technology and to fit the individual customer. 2. The second characteristic of this production was that only the upper part of the shoe was produced by machines. The sole and the other parts were prepared by hand by highly skilled workmen. This, of course, explains why the shoes manufactured at the Specialized Shoe Enterprise had a higher standard of quality in comparison with those of other European countries. In fact, almost every day [] technicians visiting us from other Satellite countries, as well as from Western Europe, who studied our methods of manufacture and placed orders with our firm. The shoes sold for 1200 forints a pair. 3. This concern did not manufacture for the local Hungarian market. Our largest orders came from the USSR and other Satellite countries. This explains in part why our methods of manufacture were different from those used in other Hungarian shoe factories. 4. [] the leather goods and other materials used in the boots and shoes ordered by the USSR had a different quality, especially in the methods of tanning the leather. Leather used for boots and shoes destined for the USSR received a special tanning both increasing the flexibility of the leather and making it so that it would not crack in either very cold or very hot weather. Also, at either extreme of temperature it did not stiffen. [] how these special tanning procedures were carried out nor [] the formula [] for the tanning compound used in this process [] the leather in a prepared form for manufacture from a supplier. 5. When the upper part of the shoes (top, vamp, cap) were cut from the tanned hide, [] it not be rough or striped. This was most important in the top but considered less so with leather going into the cap (toe) and backstay. 6. Leather always was put on the last in such a way as to have any stretching or expansion tend toward the heel, precluding the possibility of stretching in a sideways direction. This process had its significance in its contribution to an increased quality in the product. Such small, but important measures occurred several times in the manufacture of these shoes, either in the making of the upper or of the sole, all part of the quality of the workmanship. [] 			
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[redacted] These are tricks of the trade known only to the best of shoemakers and used by them. These techniques could be applied by the use of properly-designed, new machinery in regular shoe factories if it would be possible to increase the market price of the product.

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7. [redacted] "slivfale's" were used to make the uppers thinner at the bottom edge where they join the sole for a margin of about 5 mm. "Szikkolas" were used to fix the uppers to the sole in the next process. [redacted] these two steps are similar to the process of shoe manufacture [redacted] although all steps are carried out [redacted] by machinery. 25X1
8. Another special procedure [redacted] which was different [redacted] was the use of goat leather, instead of linen, for the lining. Also, a special heat and water resistant linen was placed between the outer leather of the upper and the goat skin lining. This special linen was flexible and creaseless. This linen layer was not glued to the other layers except at the seams, where additional strips of linen were placed. 25X1
9. When the cap (toe) was put on the leather upper, a glue was used as a cementing material. The parts of the upper were glued together next and hammered preparatory to stitching. 25X1
10. In stitching, [redacted] a strong looping and a thin needle. [redacted] several rows in stitching. After stitching, [redacted] cleaned the cement from the leather and gave the uppers to the workers who did the lower part of the shoes. 25X1
11. The lasts were formed by hand according to the given measurements. The inner sole was fastened in first. Next the upper was put on the last after it had been powdered with talcum.
12. The next step was the fastening of the upper part to the last with the "szikkolas" cleaning, stitching around the edge and hammering.
13. A layer of cork dust mixed with "AGO" (a compound of celluloid) was put on the bottom of the inner sole, covering the entire area of the insole. A thin layer of waterproof linen was next, followed by another layer of cork and "AGO". Finally the outer sole was glued to the last layer of "AGO" (having been softened first with water), fastened with a few nails, hammered and placed upon a "leather pillow" to break in and dry the shoe. This was done for twenty minutes, after which [redacted] started to stitch the first outsole to the insole, around the edge (called "goyzer stitching"). The thread was silk which was woven from eight thinner strands and waxed. 25X1
14. A second sole was then glued to the first outsole over a layer of "AGO", nailed with a few nails, trimmed and stitched around in an indentation provided around the outer side for the stitching. This indentation was then filled with paste and hammered ("Balso hurok dobasu goyzerce"). At each stitch, the loop was tied (binded) so that if it broke the other, adjoining stitches would remain fast.
15. The next step was the making of the heel. The inside of the heel was cut out and filled with cork, probably to make it lighter. When filled, it was closed with a layer of leather and nailed with copper nails in such a manner that the nails could not be seen. [redacted] used the "bimzeles" (a turning disk on which a few layers of linen were fastened and which was used to clean the leather), smoothing, finishing, dyeing, pitching and shining. The trade mark was put in next, being placed at the heel end of the insole [see below]. 25X1
16. Additional steps included straightening the stitching, ironing the lining and using "radlizas" to make the edge of the sole around the upper like a rasp, and coloring the thread. After this, [redacted] took out the last and fixed the inner 25X1

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part of the shoe, placing the lining. The shoes then went to the women workers who shined, ironed and packed them.

17. In general, Hungarian shoe factories are supplied with old, obsolete machinery. A few of the newer machines included: (a) "szeikkolo"—which puts on the last; (b) "ramazo"—which makes the edge; (c) "talpszogelo"—for nailing the sole; (d) "talpuarro"—for stitching the sole and (e) "talphengerelo"—a sole roller. These machines did not change essentially from earlier models. They were imported from Czechoslovakia and East Germany.

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18. At the Specialized Shoe Enterprise [] used the "Pfaff 34" and "Singer 11" toe-stitching machines. [] a few "Textima" brand toe-stitching machines from East Germany but they were very inferior both in terms of overall work quality and in actual construction. [] a great deal of trouble with the "Textima" machines. [] used the "Karos-Ollos" lining sewing machines. (The lining is glued to the leather but stitched around the edge by this machine which cuts the edge and stitches at the same time.) [] used a "sakkozo", or rasping machine, and hole-making machines []

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19. [] used the "slirfelo" double-stitching machines for stitching the insole and shank, one or both. [] used the "stancolo", a sharp cutting machine which cuts the sole from above by pressure, for rough-cutting the soles. [] used a "polishing combinat", a universal machine with two or three horizontal axes for the cleaning and polishing of the sole edge and heel with brush and "bimzelo" (linen-covered disk) machine.

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20. [] worked at time on shoes with rubber heels which were exported. [] special edge-polishing machines for these shoes (which were vibration-free) with polishing disks having coarse granules in order to avoid higher temperatures and burning the rubber.

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- (1) "Erbeitz"—the trade mark used in the shoes. It was in gold print (see design), imprinted deeply into the inside heel pad of the shoe. A temperature of about 180° C was used. The leather was marked with gold paint which covered a piece of paper.
- (2)-(4) Designs which carried the text "Shoemaker's Inc., Made to Measure, Budapest, Made in Hungary" ("Mertekutani Cipokeszito Vallalat")
- (5) Design "M.C.V." (abbreviation for above)
- (6) Drawing of shoe showing placing of "Erbeitz" trade mark, the top of the word being toward the toe.

Note: "Erbeitz" was the only one of the five trade marks used by our factory. The others were on dies and ready for use []

[] mark a shoe manufactured at the Specialized Shoe Enterprise, Budapest. UNCLASSIFIED/

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